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Chang

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(54) SEMICONDUCTOR DEVICE WITH GROUP III-V CHANNEL AND GROUP IV SOURCE-DRAIN AND METHOD FOR MANUFACTURING THE SAME

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(30) **Foreign Application Priority Data**

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H01L 31/00 (2006.01)

(52) **U.S. Cl.** **257/24**

(58) **Field of Classification Search** 257/335, 257/336, 344, 345, E29.297–E29.298, 19, 257/E33.009, E31.035, E29.104, E29.193, 257/E21.093, E21.102, E21.182, E21.207, 257/E21.371, E21.387, E21.403–E21.407, 257/E21.441, E21.445, 9–39, 51, 85, 90, 257/94, 96, 97, 183–201; 438/212, 213, 438/216, 217, 282, 289

See application file for complete search history.

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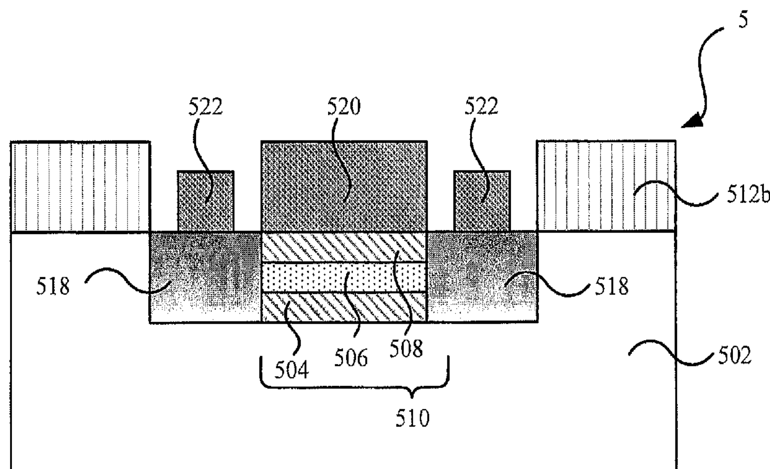
(57) **ABSTRACT**

The present invention is related to a semiconductor device with group III-V channel and group IV source-drain and a method for manufacturing the same. Particularly, the energy level density and doping concentration of group III-V materials are increased by the heteroepitaxy of group III-V and group IV materials and the structural design of elements. The method comprises: preparing a substrate; depositing a dummy gate material layer on the substrate and defining a dummy gate from the dummy gate material layer by photolithography; performing doping by self-aligned ion implantation using the dummy gate as a mask and performing activation at high temperature, so as to form source-drain; removing the dummy gate; forming a recess in the substrate between the source-drain pair by etching; forming a channel-containing stacked element in the recess by epitaxy; and forming a gate on the channel-containing stacked element.

14 Claims, 23 Drawing Sheets



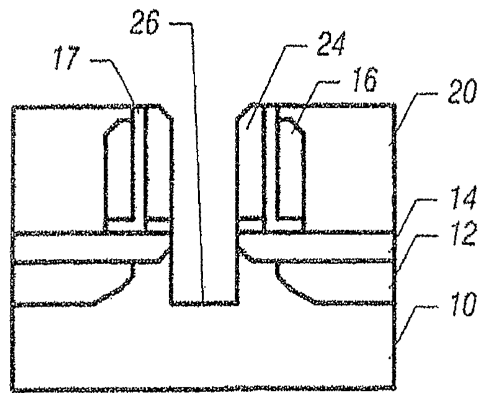


Fig. 1
Prior Art

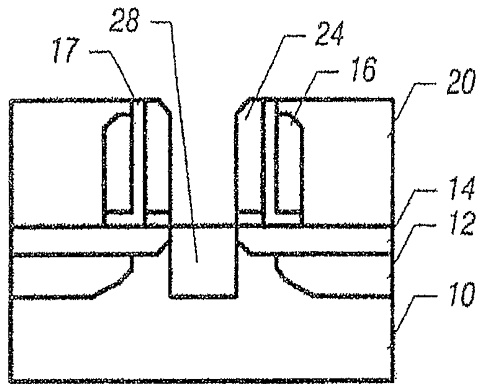


Fig. 2
Prior Art

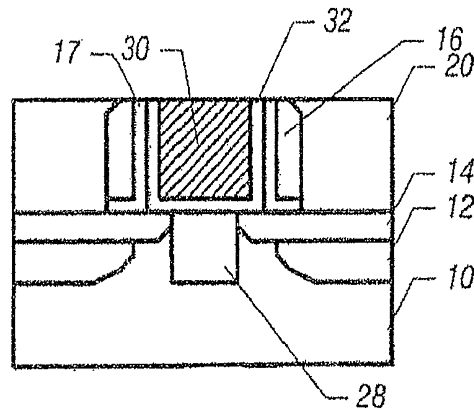


Fig. 3
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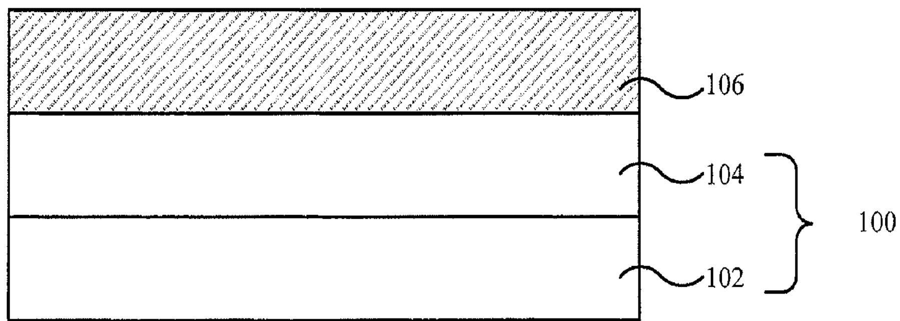


Fig. 4

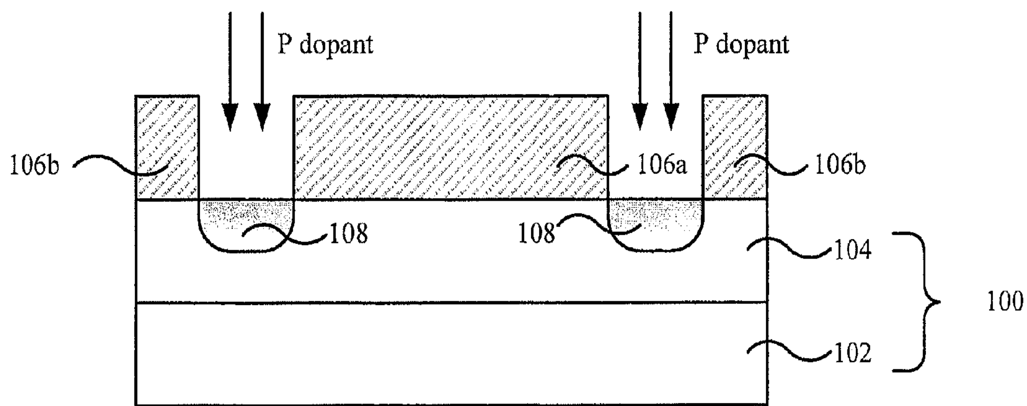
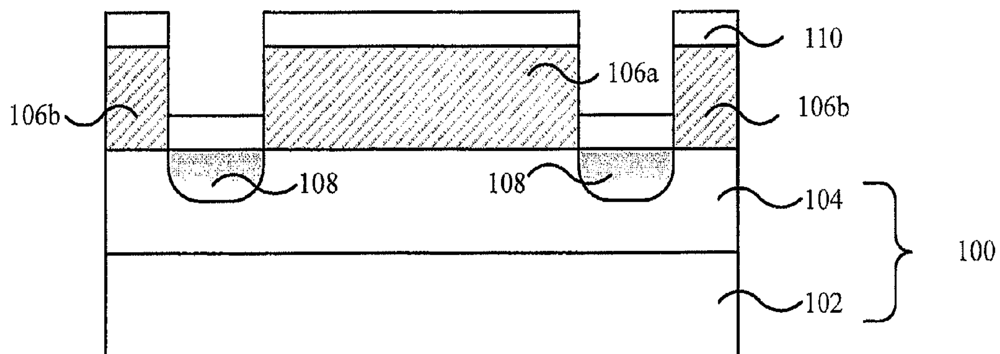


Fig. 5



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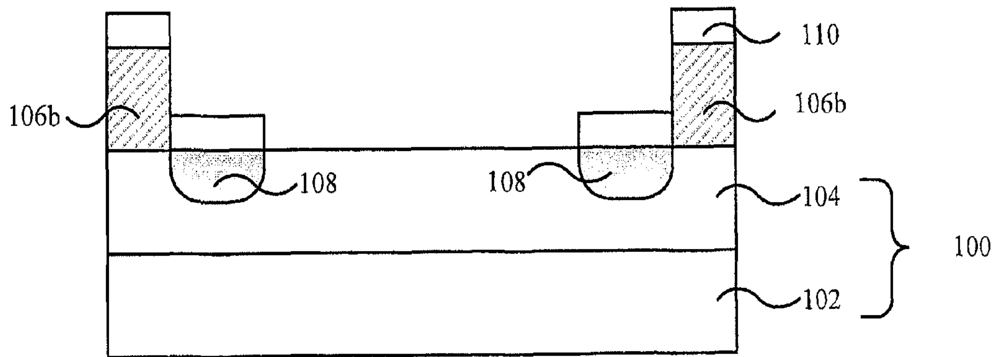

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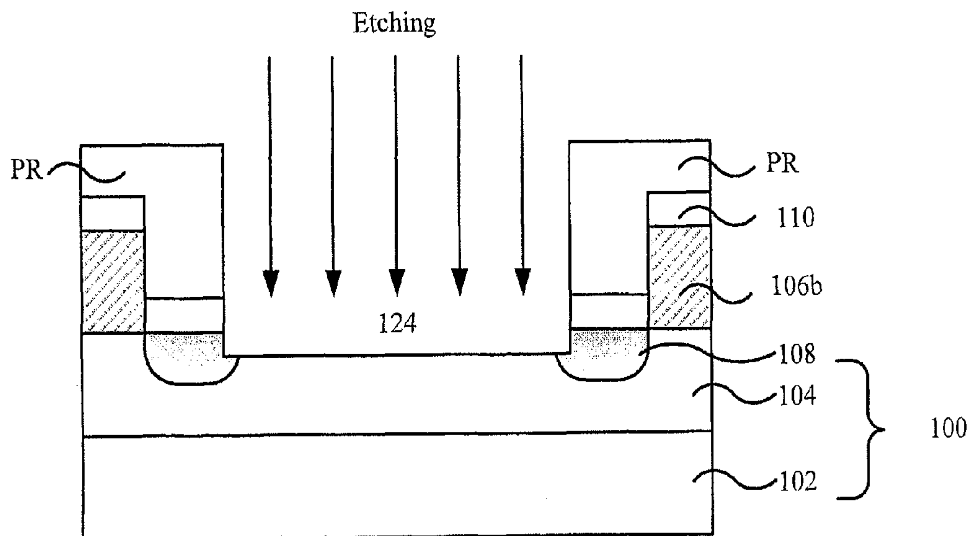

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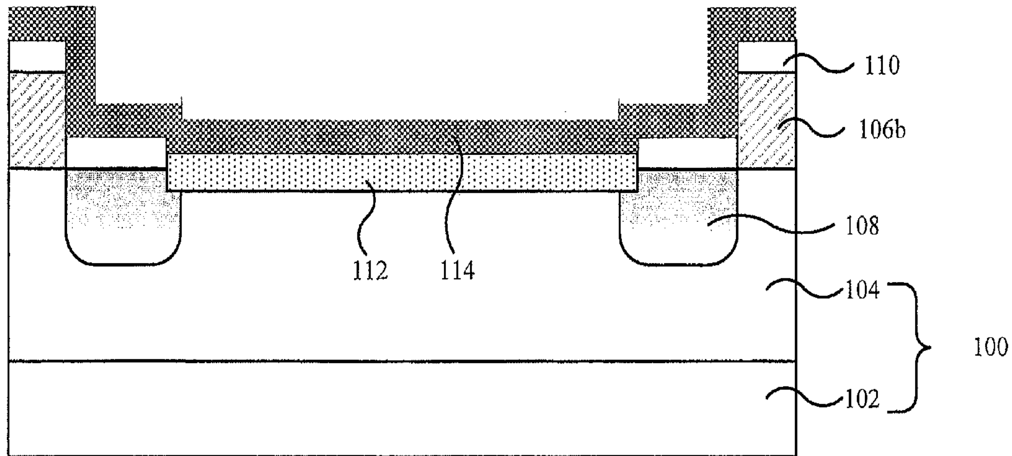

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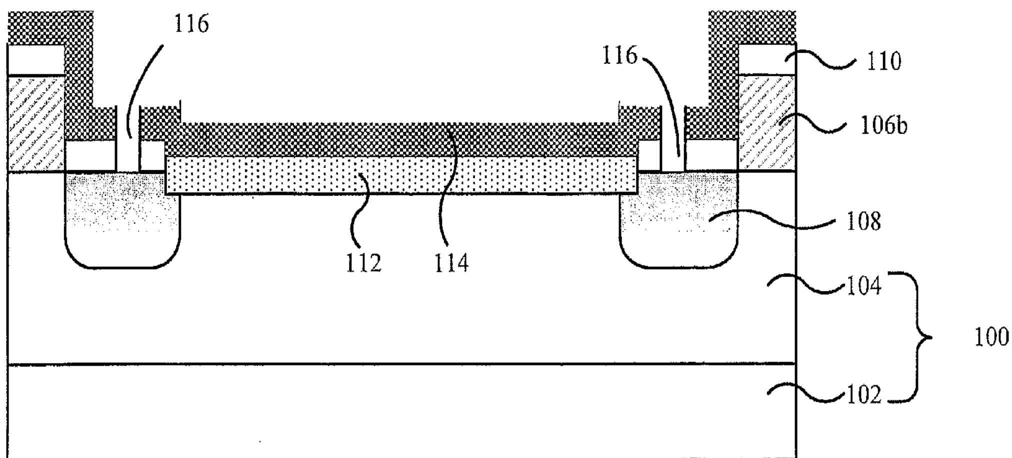

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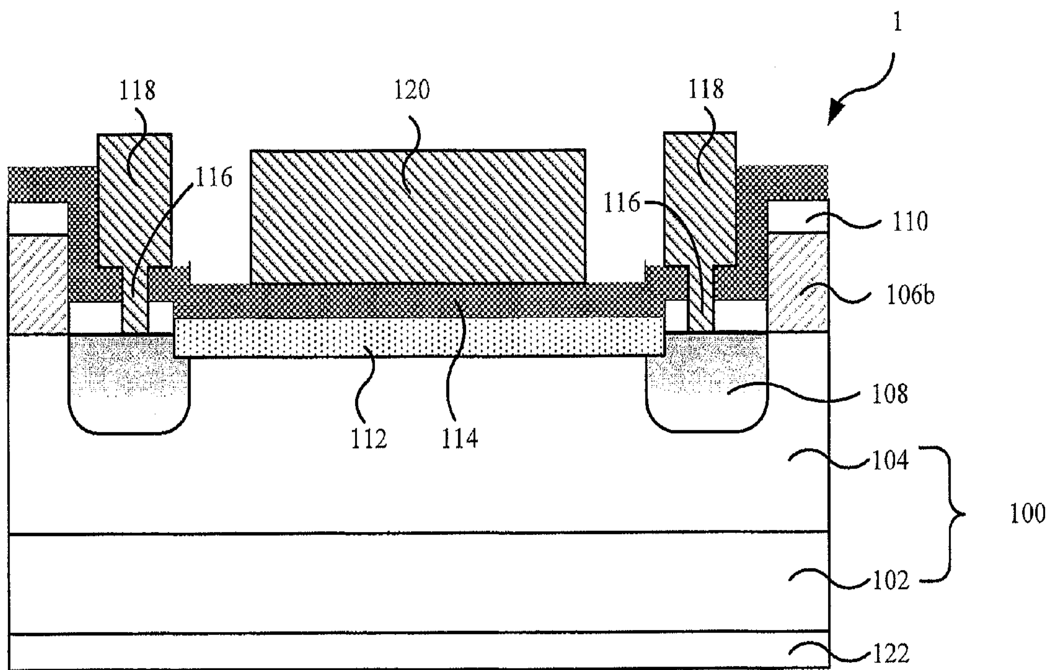

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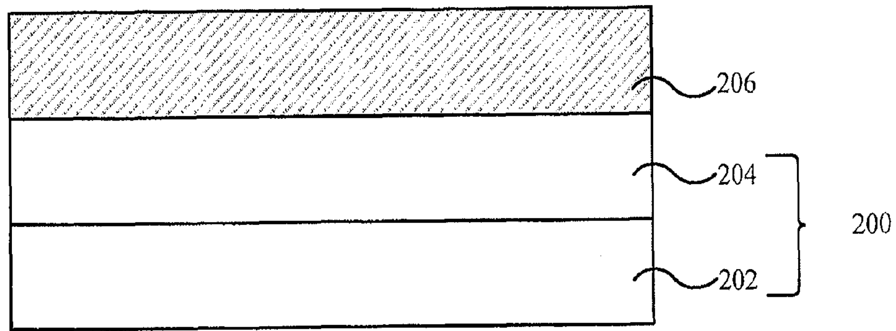

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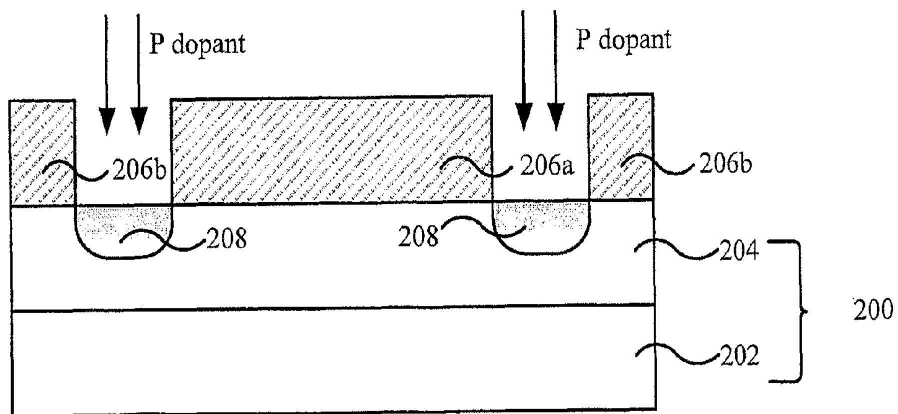

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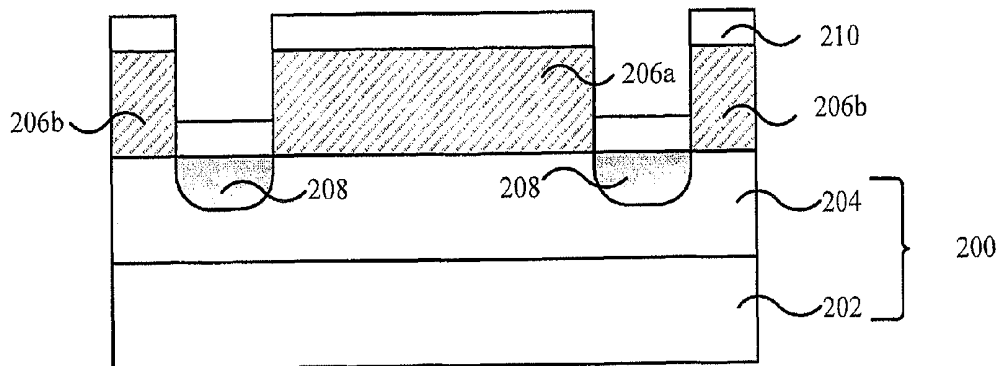

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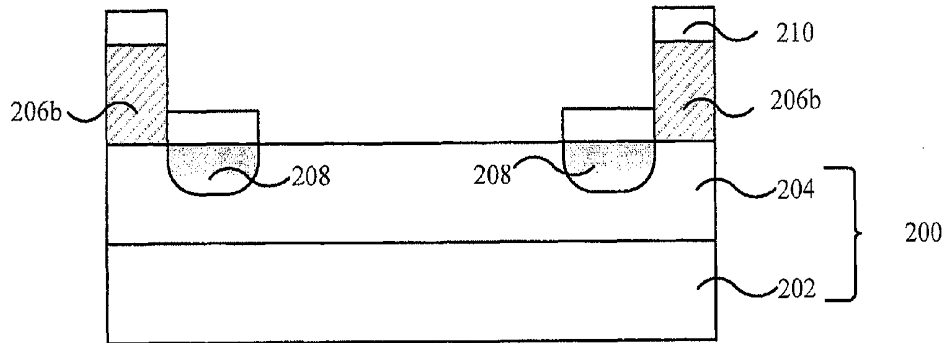

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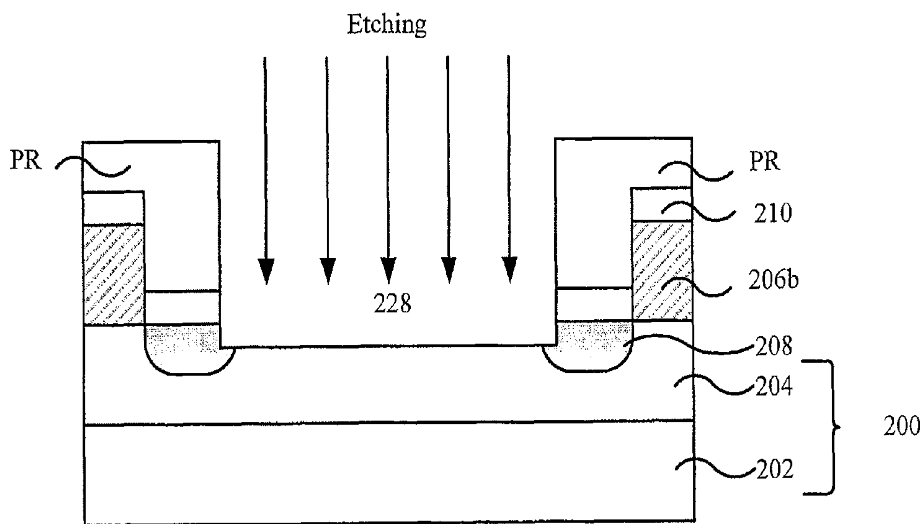

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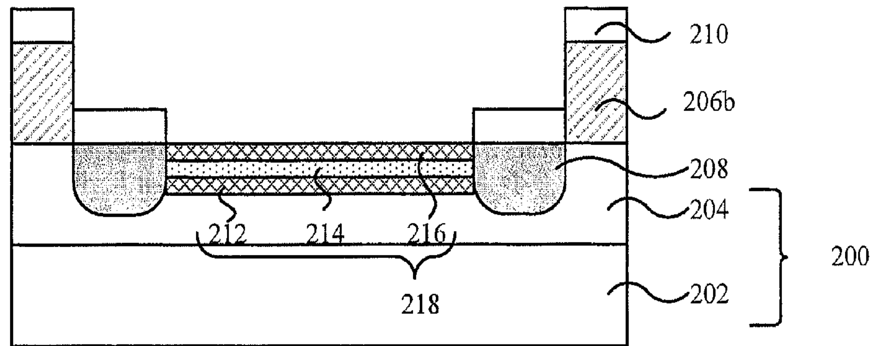

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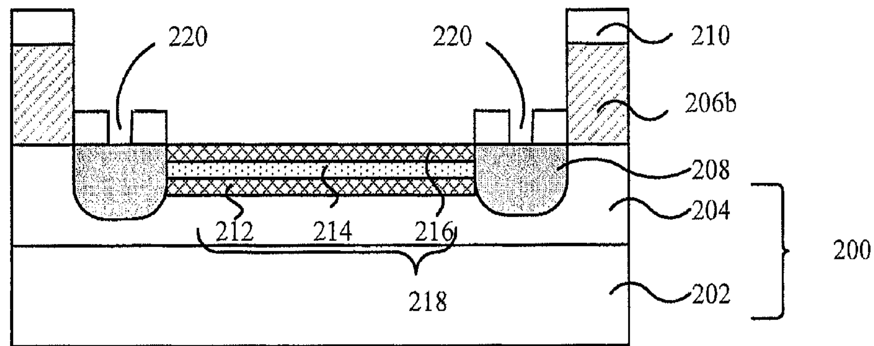

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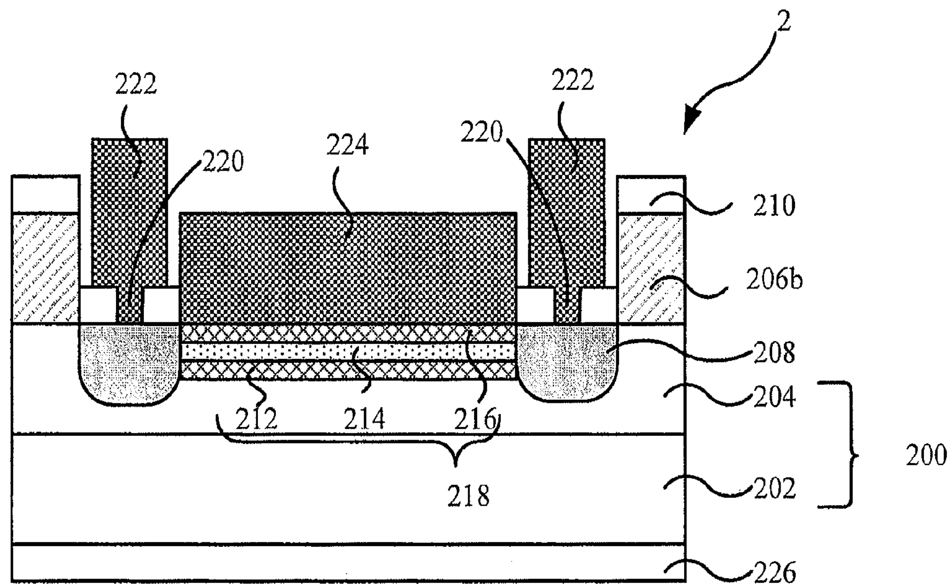

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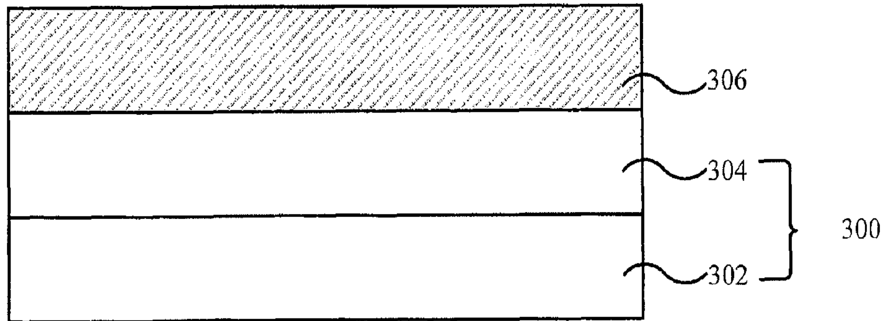

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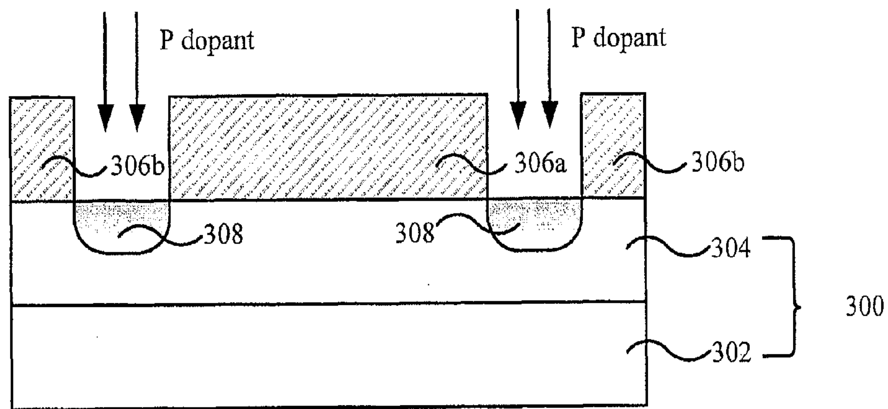

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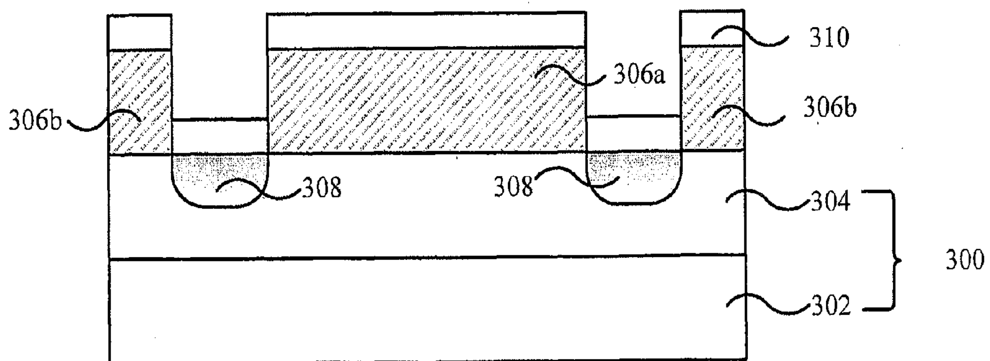

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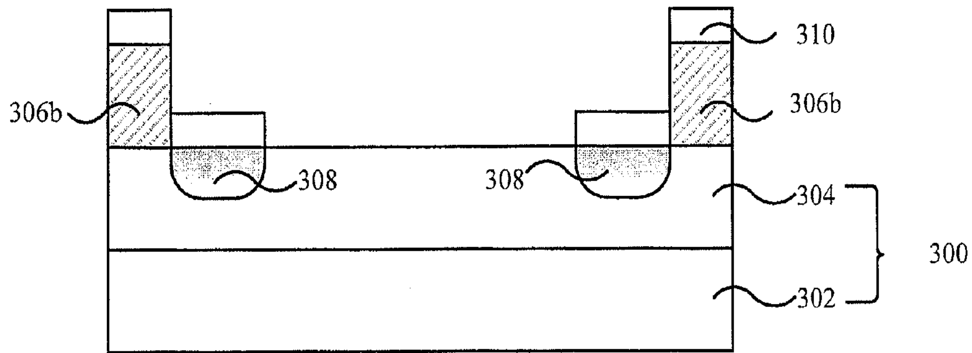

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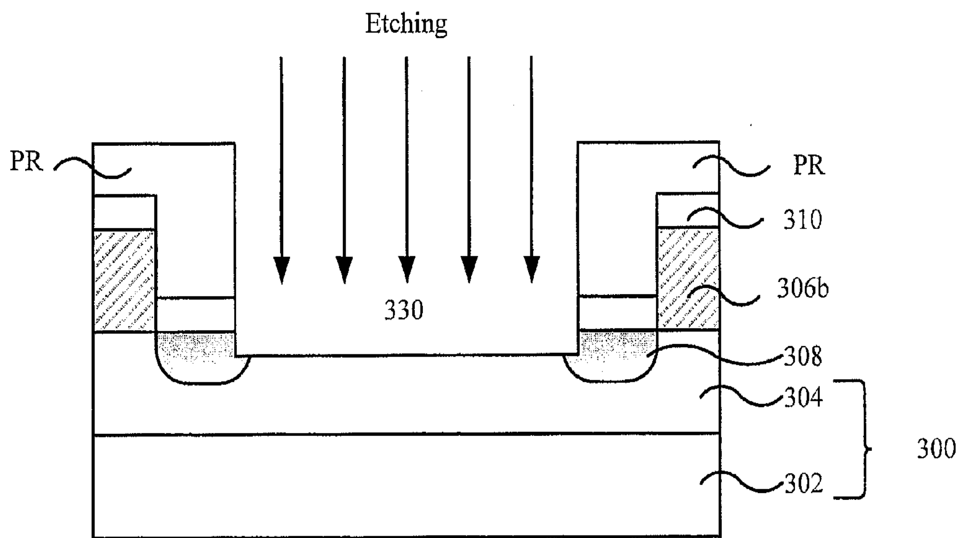

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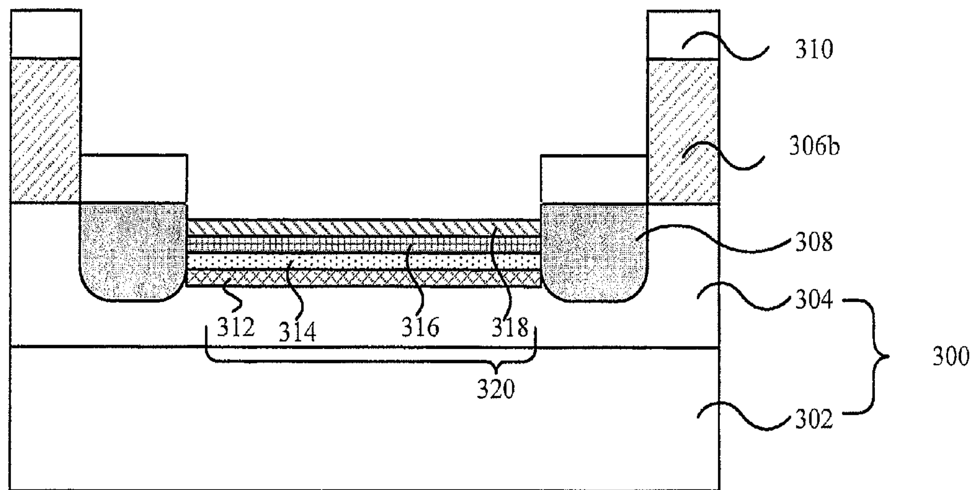

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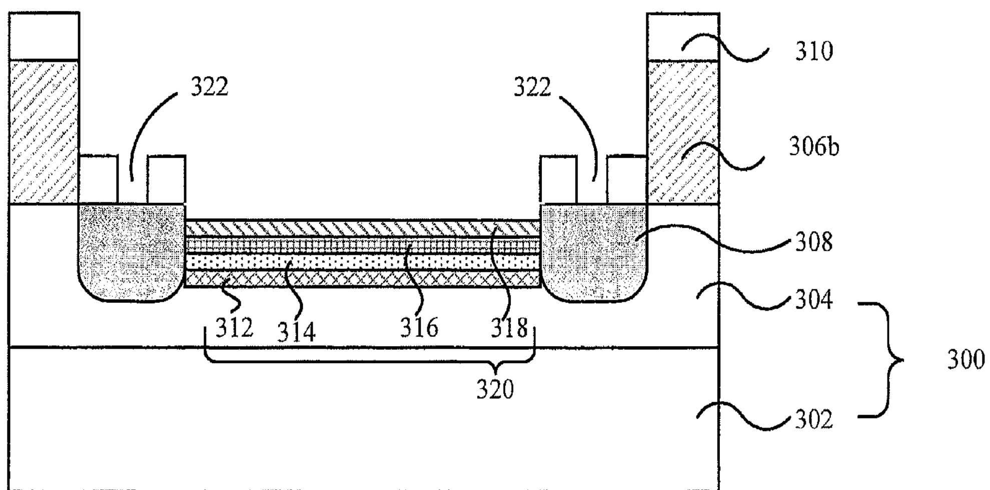

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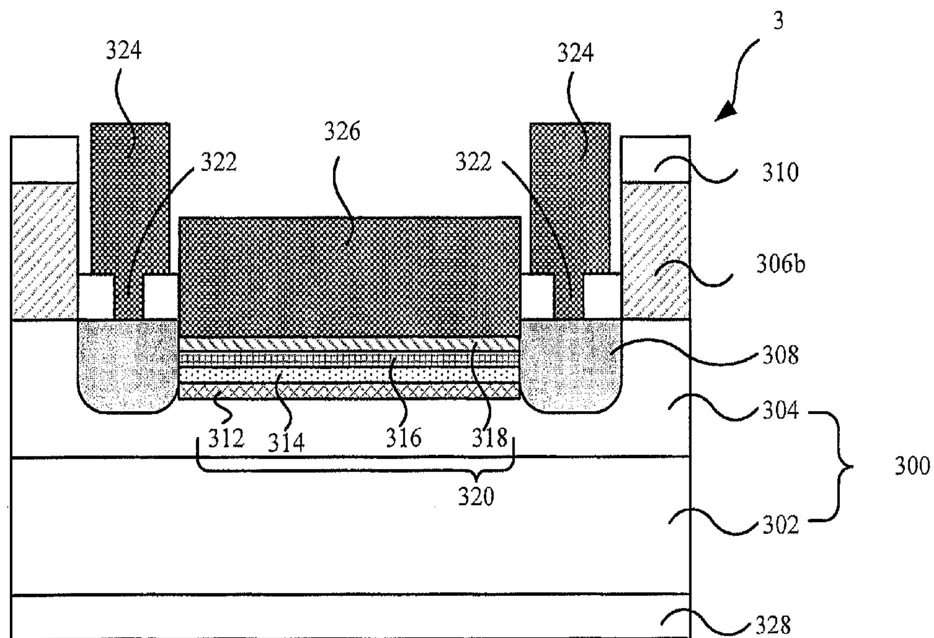

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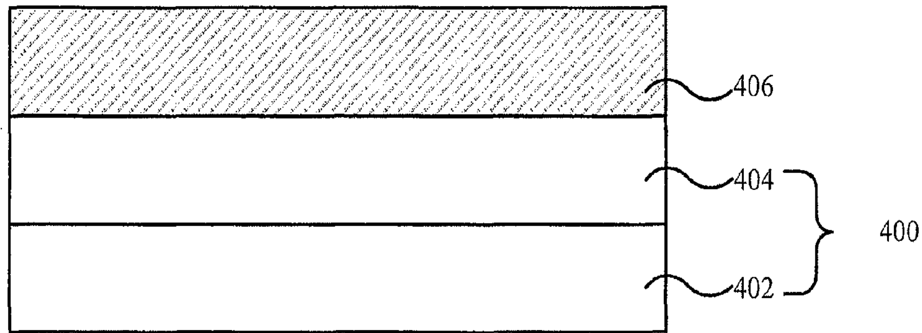

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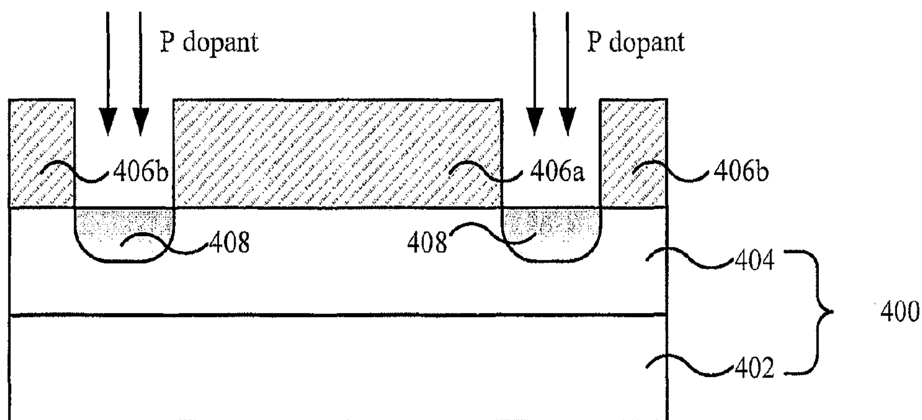

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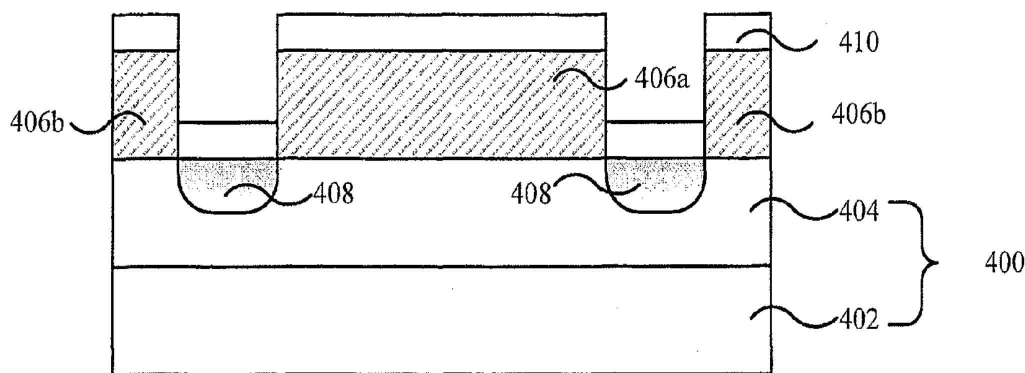

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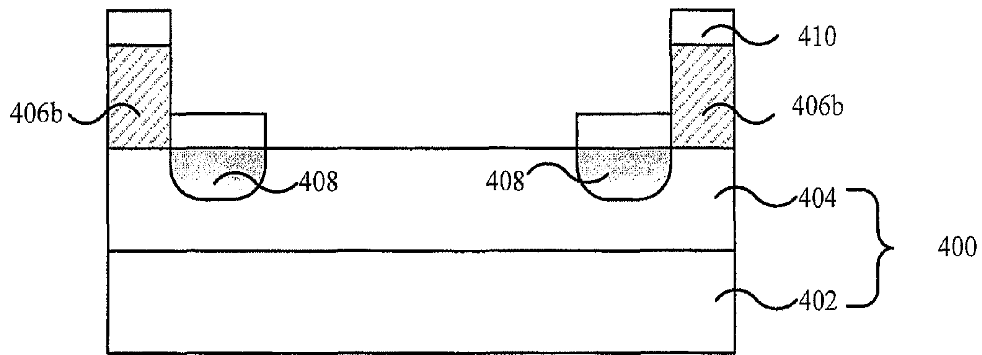

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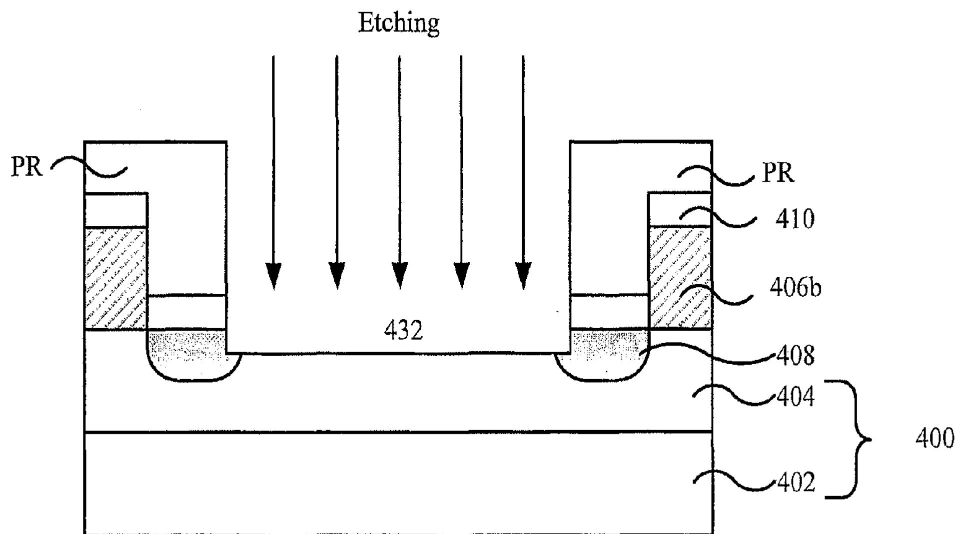

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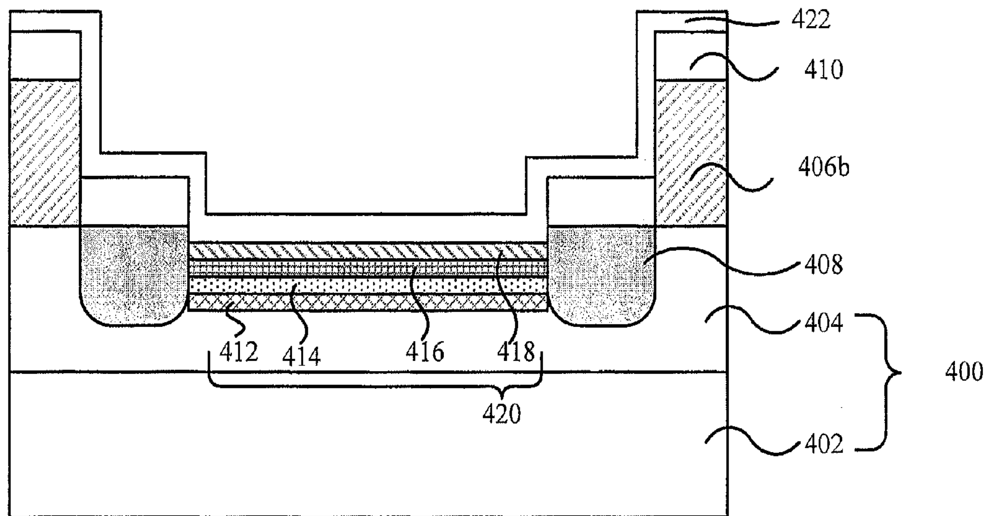

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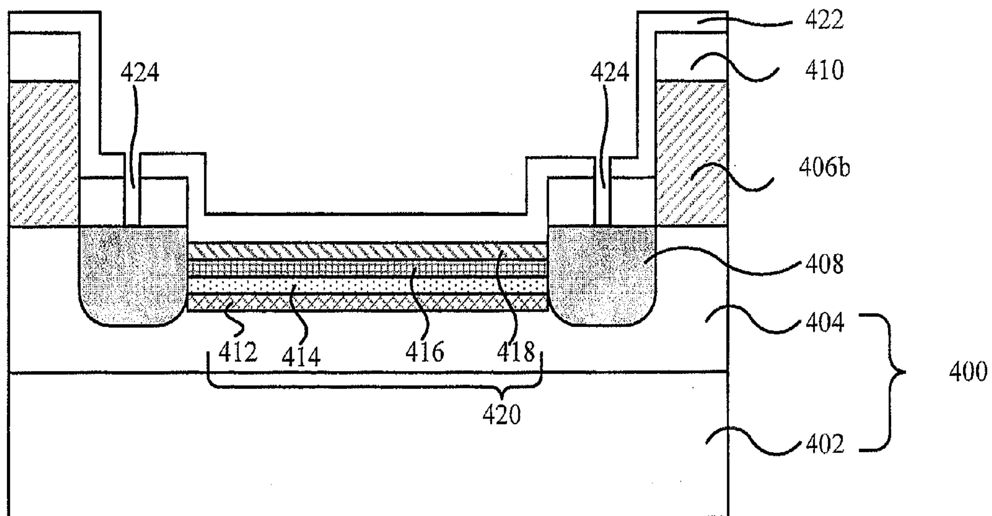

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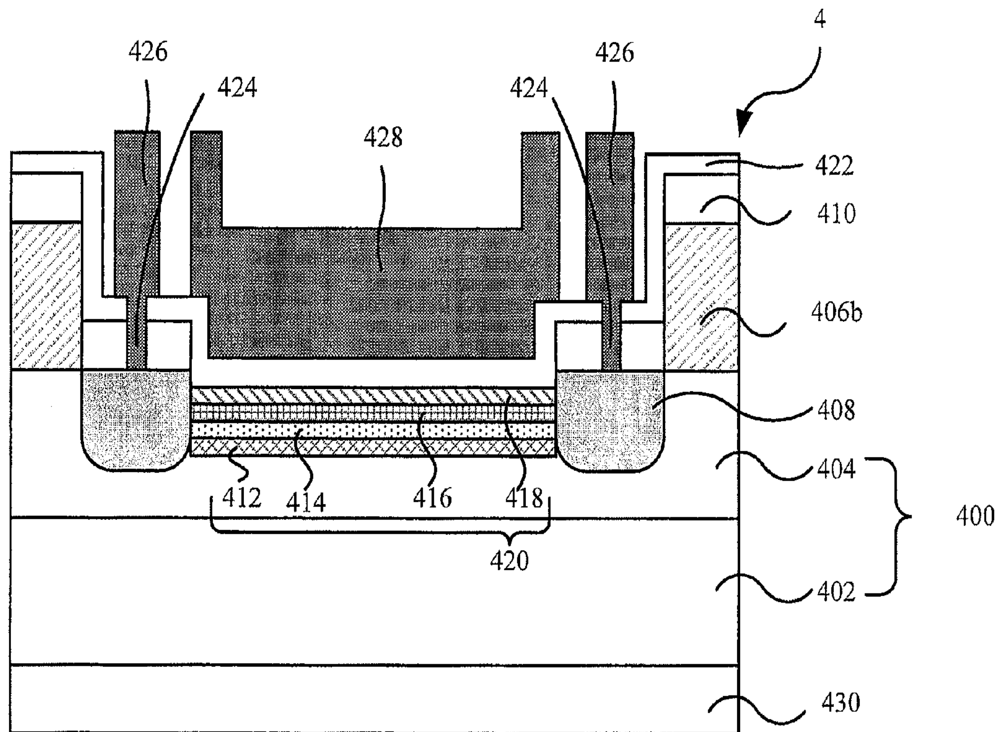

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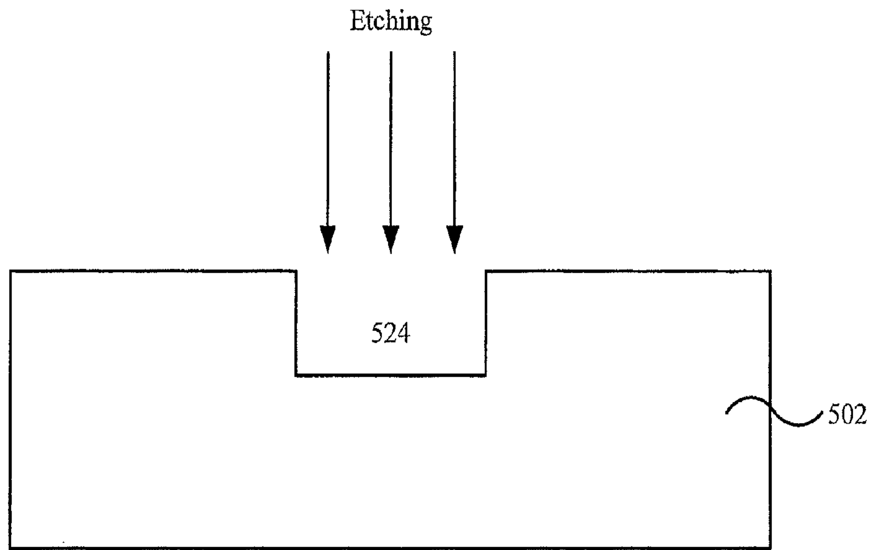

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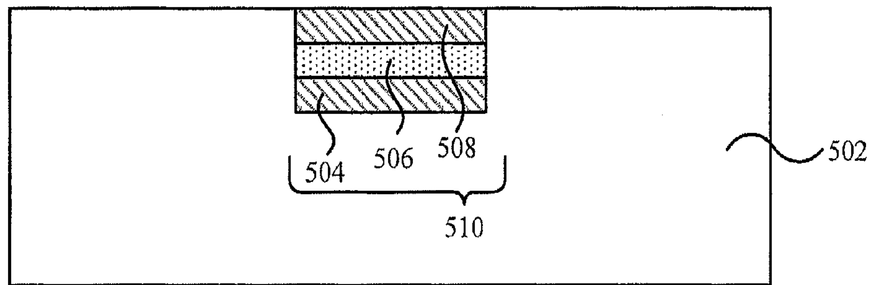

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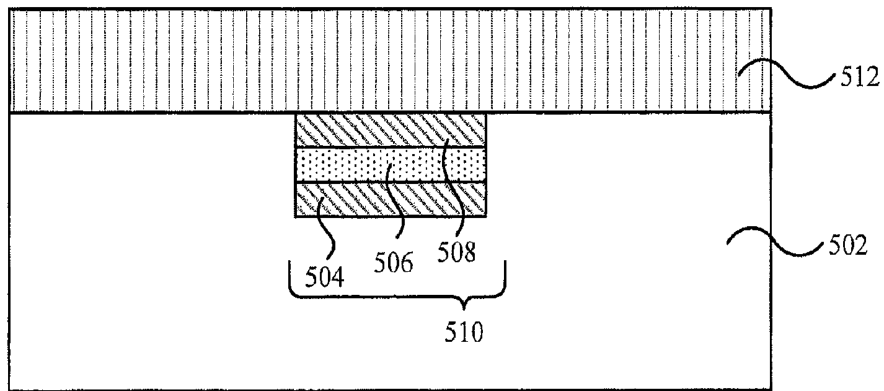

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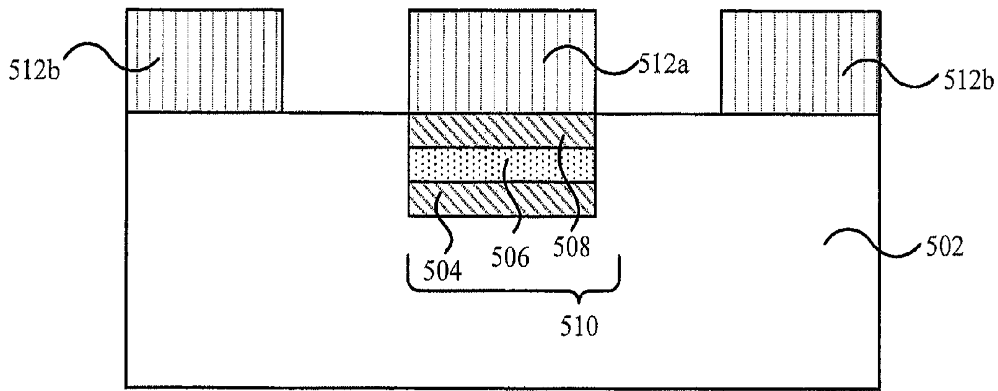

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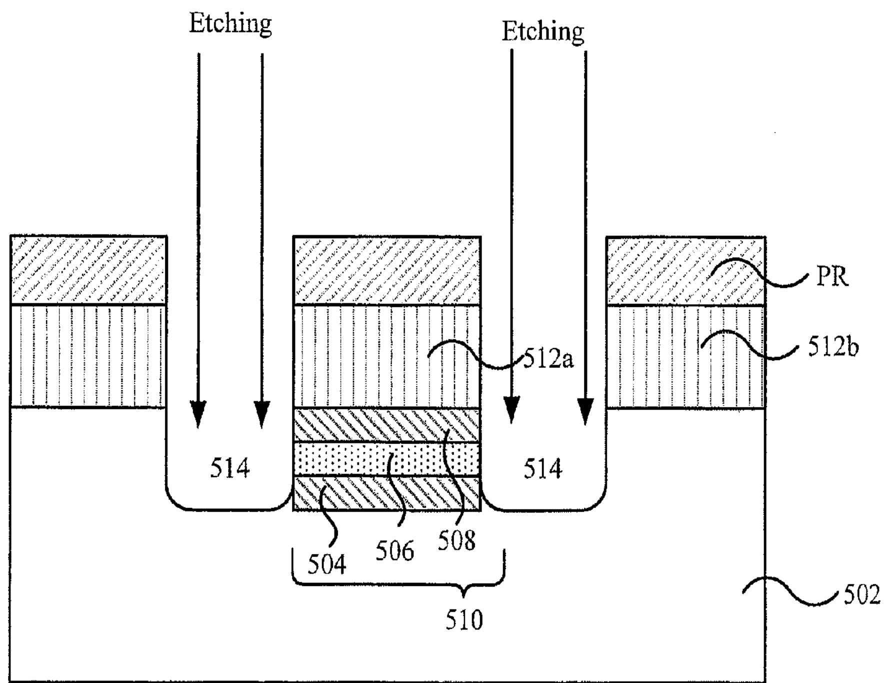

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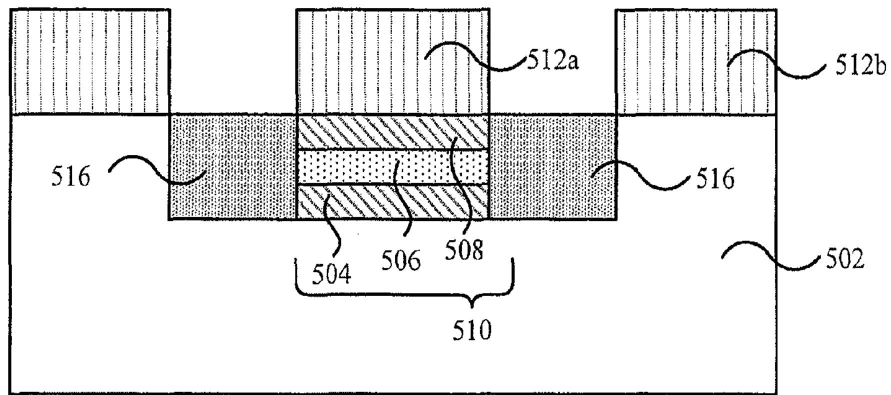

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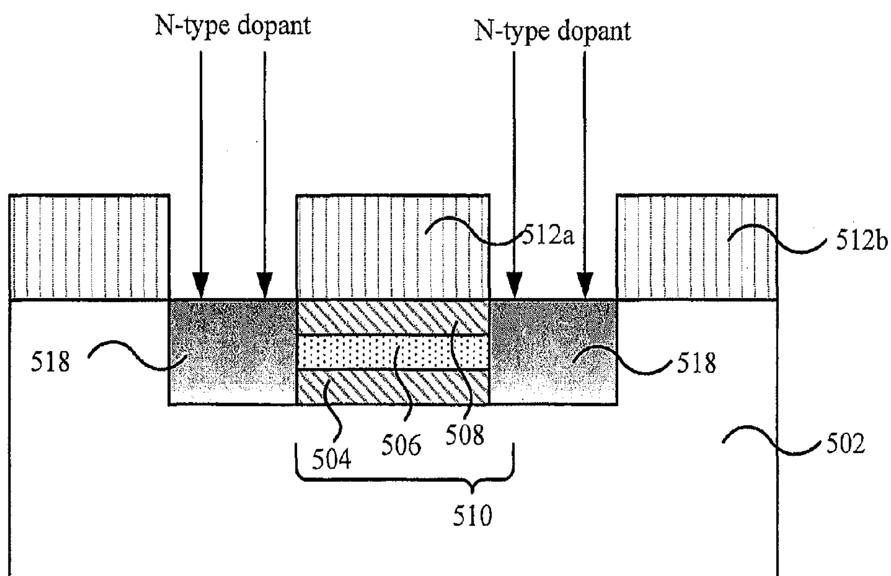

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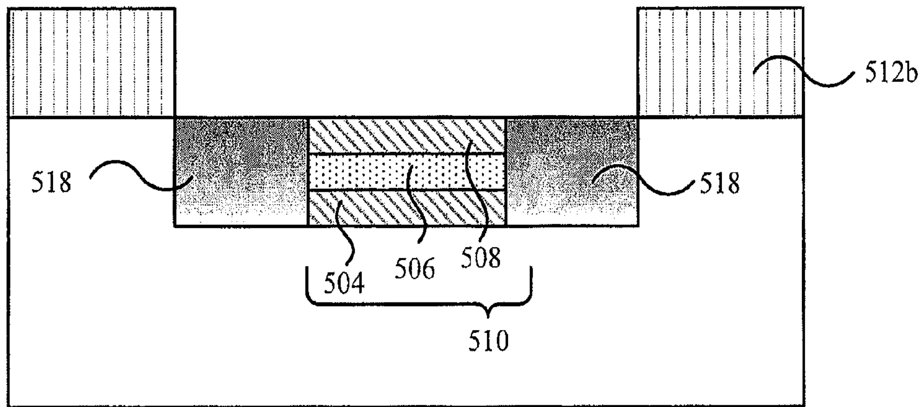

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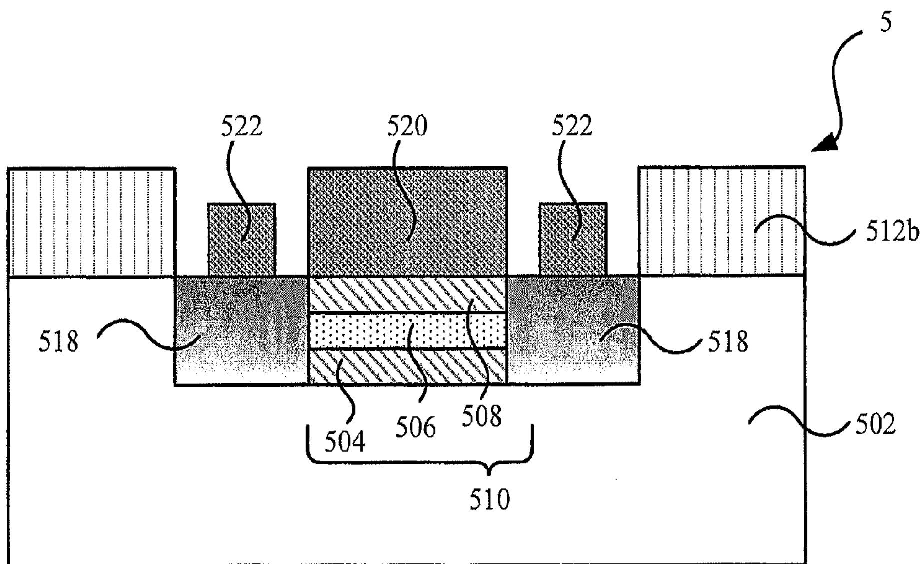

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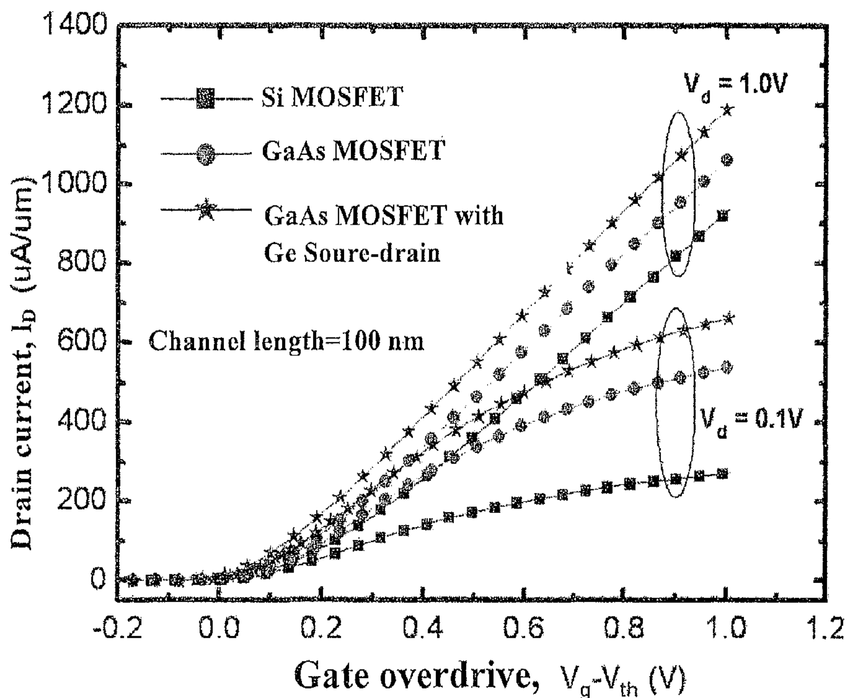
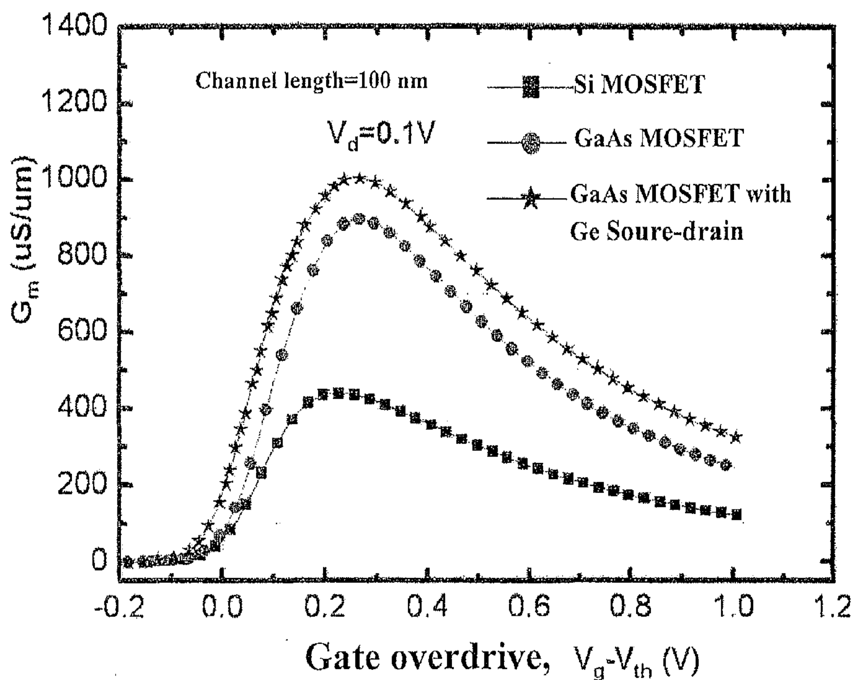


Fig. 45



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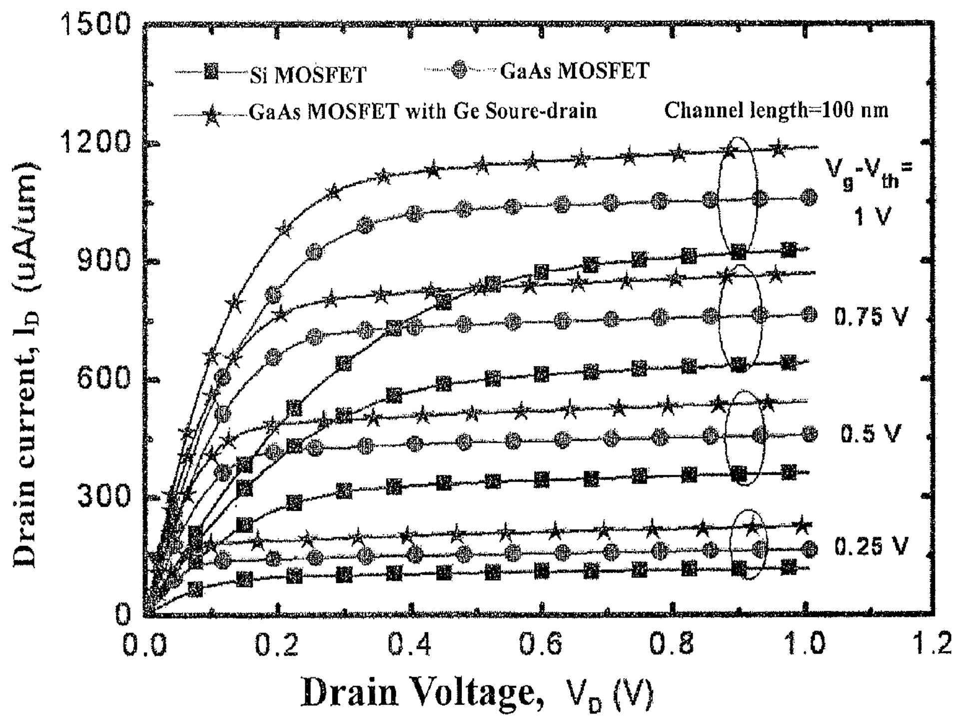

Fig. 47

SEMICONDUCTOR DEVICE WITH GROUP III-V CHANNEL AND GROUP IV SOURCE-DRAIN AND METHOD FOR MANUFACTURING THE SAME

CROSS-REFERENCE TO RELATED APPLICATION

This application claims all benefits accruing under 35 U.S.C. §119 from Taiwanese Patent Application No. 098140529, filed on Nov. 27, 2009 in the Intellectual Property Office Ministry of Economic Affairs, Republic of China, the disclosure of which is incorporated by reference herein.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention is related to a semiconductor device with group III-V channel and group IV source-drain and a method for manufacturing a semiconductor device with group III-V channel and group IV source-drain. The method is to form a group III-V channel on a group IV substrate by epitaxy, or a group IV source-drain on a group III-V element structure by epitaxy.

2. Description of the Related Art

Generally, a metal-oxide-semiconductor field effect transistor (MOSFET) with very thin gate dielectrics made from silicon dioxide may experience unacceptable gate leakage currents, so the gate dielectrics is formed with a high-dielectric-constant dielectric material, instead of silicon dioxide, thereby reducing the gate leakage current. Herein, the high dielectric constant refers to a dielectric constant higher than 10.

However, since the high-dielectric-constant gate dielectric layer may not be compatible with polysilicon, it may desirable to use metal gate electrodes in devices that includes the high-dielectric-constant gate dielectric. When a CMOS device with metal gates is made, it may be necessary to make the NMOS and PMOS from different materials. A replacement gate process may be used to form gates from different materials. In the process, a first polysilicon layer, bracketed by a pair of spacers, is selectively removed as a second polysilicon layer to create a trench between the spaces. The trench is filled with a first metal. Then, the second polysilicon layer is removed and replaced with a second metal that differs from the first metal.

US Patent Application Publication No. 2006/0046399A1 disclosed a method for forming a replacement metal gate electrode. A dummy dielectric layer and a sacrificial layer are sequentially formed on a silicon substrate **10**. The dummy dielectric layer and the sacrificial layer are patterned, and a shallow source drain region **14** is formed by ion implantation using the patterned sacrificial layer as a mask. Sidewall spacers **16** and **17** are sequentially formed on the opposite sides of the sacrificial layer. Ion implantation is performed once again to form a deep source drain region **12**. A dielectric layer **20** is deposited on a resultant structure, and the dielectric layer **20** on the patterned sacrificial layer is removed by chemical mechanical polishing. The sacrificial layer is removed to form a hole that is positioned between the sidewall spacers **16** and **17**. A sidewall spacer **24** is formed in the hole. The dummy dielectric layer is removed by wet etching. As shown in FIG. **1**, the portion of the silicon substrate **10** to be functioned as a channel portion, which is exposed by the opening between the sidewall spacers **24**, is etched by dry etching, to form a trench **26**. As shown in FIG. **2**, a part of the trench **26** is filled with an epitaxial material **28** such as silicon germanium, germanium, InSb, or carbon-doped silicon to the level of the upper surface of the shallow source drain region **14**. As shown in FIG. **3**, the sidewall spacer **24** is removed. A U-shaped high-dielectric-constant dielectric layer **32** is formed. An N-type metal layer **30** is formed on the dielectric layer **32**.

SUMMARY OF THE INVENTION

The Problems to be Resolved by the Present Invention

In the above-mentioned method, the trench **26** is formed in the substrate and is filled with an epitaxial material functioning as a carrier channel by depositing a single epitaxial film (i.e., the epitaxial material is a single layer without structural design), so the electrical properties of the manufactured devise are susceptible to the quality of epitaxial junction and can not efficiently confine carriers. Additionally, in the above-mentioned method, the depth of the trench **26** is arranged to be the same as the depth of the deep source drain region **12**. However, for the heteroepitaxial material, the defects of the heterogeneous material may extend upward to the surface of the channel portion, resulting in degradation in electrical properties. Therefore, this arrangement is not optimized.

Although that a group III-V material is integrated into a silicon substrate to be a logic electronic device, can efficiently enhance the electrical properties of the device, once element sizes are micronized below 22 nm, a field effect transistor using the group III-V material will confront the problems of insufficient energy level density and doping concentration.

The Methods for Resolving these Problems

For resolving these problem, the inventor submits a concept that the device is designed taking the depth of the channel portion into consideration.

An aspect of the present invention is a semiconductor device with group III-V channel and group IV Source-drain, comprising: a substrate, selected from one of the group consisting of a Si substrate, a Ge substrate, a Si substrate with Si_xGe_{1-x} (x=0~1) or GaN or silicon germanium carbide grown thereon, a Ge substrate with Si_xGe_{1-x} (x=0~1) or GaN or silicon germanium carbide grown thereon, and a diamond substrate with Si_xGe_{1-x} (x=0~1) or GaN or silicon germanium carbide grown thereon; source-drain, formed by doping a specific part of the substrate by ion implantation; a channel-containing stacked element, formed to connect the source-drain by forming a recess in the substrate between the source-drain pair and filling the recess with a group III-V material by epitaxy; and a gate, formed on the channel-containing stacked element.

Another aspect of the present invention is to combine a group III-V carrier channel and group IV source-drain by two different epitaxial techniques.

One of them is a group III-V epitaxial technique, in which group IV source-drain are first formed, and a group III-V channel is stacked. Particularly, it comprises the steps of: preparing a substrate, the substrate selected from one of the group consisting of a Si substrate, a Ge substrate, a Si substrate with Si_xGe_{1-x} (x=0~1) or GaN or silicon germanium carbide grown thereon, a Ge substrate with Si_xGe_{1-x} (x=0~1) or GaN or silicon germanium carbide grown thereon, and a diamond substrate with Si_xGe_{1-x} (x=0~1) or GaN or silicon germanium carbide grown thereon; depositing a dummy gate material layer on the substrate and defining a dummy gate from the dummy gate material layer by photolithography;

doping the exposed region of the substrate by self-aligned ion implantation using the dummy gate as a mask and activating the exposed region at high temperature, so as to form source-drain; removing the dummy gate; forming a recess in the substrate between the source-drain pair by etching, the recess having a depth required for forming a channel-containing stacked element by subsequent epitaxy; forming the channel-containing stacked element in the recess with a group III-V material by epitaxy; and forming a gate on the channel-containing stacked element.

The other is a group IV epitaxial technique, in which a group III-V channel is first stacked, and group IV source-drain are formed. Particularly, it comprises the steps of: preparing a substrate, the substrate being a group III-V substrate or a Si substrate with GaN grown thereon; forming a recess in the substrate by etching, the recess having a depth required for forming a channel-containing stacked element by subsequent epitaxy; forming the channel-containing stacked element in the recess with a group III-V material by epitaxy; depositing a dummy gate material layer on the substrate and defining a dummy gate from the dummy gate material layer by photolithography; forming a source-drain recess on the substrate by using the dummy gate as a mask; filling the source-drain recess with a group IV material by selective heteroepitaxy using the dummy gate as a mask; doping the group IV material by self-aligned ion implantation and then, activating the group IV material at high temperature, so as to form source-drain; removing the dummy gate; and forming a gate on the channel-containing stacked element.

Furthermore, the crystal plane of the substrate is (100), (110), or (111), and its off-cut angle is 2, 4, or 6 degrees.

Also, the dummy gate material layer is a single layer made of insulating material or a stacked layer made of plural insulating materials, and the material(s) may be silicon oxide, silicon oxynitride, aluminum oxynitride, or hafnium oxynitride.

Furthermore, the source-drain are made of doped Si_xGe_{1-x} (x=0~1) or silicon germanium carbide.

Also, the channel-containing stacked element has a metal-oxide semiconductor structure, a quantum well structure, or a two-dimension electron gas structure, wherein the metal-oxide semiconductor structure consists of a metal layer, a high-dielectric-constant dielectric layer, and a group III-V channel layer; the quantum well structure consists of a large-energy-gap material layer, a small-energy-gap material layer functioning as a channel, and a large-energy-gap material layer; the two-dimension electron gas structure consists of a large-energy-gap heavily doped material layer, a large-energy-gap undoped material layer, a small-energy-gap undoped material layer functioning as a channel, and a moderate-energy-gap undoped material layer.

Furthermore, the material of the channel is InN, GaN, AlN, InP, InAs, InSb, GaAs, GaSb, or a compound consisting of them with different proportions.

Also, The present invention uses a film formation system selected from the group consisting of a metal organic chemical vapor deposition (MOCVD) system, a molecular beam epitaxy (MBE) system, an ultra-high vacuum chemical vapor deposition (UHVCVD) system and an atomic layer deposition (ALD) system to perform epitaxy.

THE EFFECTS OF THE PRESENT INVENTION

A semiconductor device with group III-V channel and group IV source-drain manufactured according to the present invention has the following advantages: (1) the problems of insufficient energy level density and doping concentration are resolved; (2) channel carriers can be efficiently confined by forming a stacked structure such as a quantum well or two-dimension electron gas or metal-oxide semiconductor; (3) the integration of the group III-V material into a silicon germanium or silicon substrate can reduce cost; and (4) the group III-V channel grown with strain can further enhance the electrical properties since the group IV source-drain, such as Si_xGe_{1-x} (x=0~1), with a relative small lattice constant can apply compressive strain to the group III-V channel, such as GaAs, with a relative large lattice constant while the group IV source-drain themselves are formed with tensile strain, wherein the compressive strain can increase electron mobility to increase current.

BRIEF DESCRIPTION OF THE DRAWINGS

FIGS. **1~3** are schematic cross sectional views showing a transistor having abrupt source-drain and a metal gate of the related prior art.

FIGS. **4~11** are schematic cross sectional views showing a metal-oxide semiconductor field effect transistor manufactured by using a group III-V epitaxy technique according to a first embodiment of the present invention.

FIGS. **12~19** are schematic cross sectional views showing a quantum well field effect transistor manufactured by using a group III-V epitaxy technique according to a second embodiment of the present invention.

FIGS. **20~27** are schematic cross sectional views showing a high-electron-mobility transistor manufactured by using a group III-V epitaxy technique according to a third embodiment of the present invention.

FIGS. **28~35** are schematic cross sectional views showing a metal-oxide semiconductor high-electron-mobility transistor manufactured by using a group III-V epitaxy technique according to a fourth embodiment of the present invention.

FIGS. **36~44** are schematic cross sectional views showing a quantum well field effect transistor manufactured by using a group IV epitaxy technique according to a fifth embodiment of the present invention.

FIGS. **45-47** are graphs showing the electrical properties I_D-V_G, G_M-V_G, and I_D-V_D of three kinds of MOSFETs listed in Table 1, respectively.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

Hereinafter, the embodiments of the present invention will be described in detail with reference to drawings.

First Embodiment

A first embodiment uses a group III-V epitaxial technique to manufacture a metal-oxide semiconductor field effect transistor **1**.

Referring to FIG. **4**, a p-type silicon substrate **102** with a p-type Si_xGe_{1-x} (x=0~1) layer **104** formed thereon is prepared. Hereinafter, the p-type silicon substrate **102** together with the p-type Si_xGe_{1-x} layer **104** are referred to as an Si_xGe_{1-x} substrate **100**. After cleaning, a first silicon dioxide layer **106** is deposited on the Si_xGe_{1-x} substrate **100**.

Referring to FIG. **5**, a dummy gate **106*a*** and a residual first silicon dioxide layer **106*b*** are defined by using photolithography. The Si_xGe_{1-x} substrate **100** is doped with P dopant by self-aligned ion implantation using the dummy gate **106*a*** and the residual first silicon dioxide layer **106*b*** as a mask, so as to form n^+ source-drain **108**. Referring to FIG. **6**, a second

silicon dioxide layer **110** is deposited to cover the entire surface. Then, the n^+ source-drain **108** are activated at high temperature.

Referring to FIG. **7**, the dummy gate **106***a* and the second silicon dioxide layer **110** above are removed by etching.

Referring to FIG. **8**, a resist PR is formed on the residual second silicon dioxide layer **110** as an etching mask, and the Si_xGe_{1-x} substrate **100** is etched to a desired depth, so as to form a recess **124**.

Referring to FIG. **9**, the resist PR is removed. A group III-V channel layer having a high electron mobility **112** is formed with a group III-V material in the recess **124** by epitaxy. A high-dielectric-constant gate dielectric layer **114** is formed on the resultant structure.

Referring FIG. **10**, contact holes **116** are defined in the second silicon dioxide layer **110** and the high-dielectric-constant gate dielectric layer **114** above the n^+ source-drain **108**.

Referring to FIG. **11**, source-drain plug contacts **118** made of TiN or TaN are formed in the contact holes **116** by metallization process, and a metal gate **120** made of TiN or TaN is formed on the high-electron-mobility group III-V channel layer **112**. Finally, a backside contact **122** made of Al is formed on the side of the silicon substrate **102** opposite to the above-grown layers.

Second Embodiment

A second embodiment uses a group III-V epitaxial technique to manufacture a quantum well field effect transistor (QWFET) **2**.

Referring to FIG. **12**, a p-type silicon substrate **202** with a p-type Si_xGe_{1-x} (x=0~1) layer **204** formed thereon is prepared. Hereinafter, the p-type silicon substrate **202** together with the p-type Si_xGe_{1-x} layer **204** are referred to as an Si_xGe_{1-x} substrate **200**. After cleaning, a first silicon dioxide layer **206** is deposited on the Si_xGe_{1-x} substrate **200**.

Referring to FIG. **13**, a dummy gate **206***a* and a residual first silicon dioxide layer **206***b* are defined by using photolithography. The Si_xGe_{1-x} substrate **200** is doped with P dopant by self-aligned ion implantation using the dummy gate **206***a* and the residual first silicon dioxide layer **206***b* as a mask, so as to form n^+ source-drain **208**. Referring to FIG. **14**, a second silicon dioxide layer **210** is deposited to cover the entire surface. Then, the n^+ source-drain **208** are activated at high-temperature.

Referring to FIG. **15**, the dummy gate **206***a* and the second silicon dioxide layer **210** above are removed by etching.

Referring to FIG. **16**, a resist PR is formed on the residual second silicon dioxide layer **210** as an etching mask, and the Si_xGe_{1-x} substrate **200** is etched to a depth required for a subsequent stacked element, so as to form a recess **228**.

Referring to FIG. **17**, the resist PR is removed. A group III-V first large-energy-gap confinement layer **212**, a group III-V small-energy-gap channel layer **214**, and a group III-V second large-energy-gap confinement layer **216** are sequentially formed in the recess **228** as a stacked element having a group III-V quantum well structure **218** by epitaxy.

Referring to FIG. **18**, contact holes **220** are defined in the second silicon dioxide layer **210** above the n^+ source-drain **208**.

Referring to FIG. **19**, source-drain plug contacts **222** made of Al are formed in the contact holes **220** by metallization process. A metal gate **224** made of Pt or Ti is formed on the stacked element having a group III-V quantum well structure **218**. Finally, a backside contact **226** made of Al is formed on the side of the silicon substrate **202** opposite to the above-grown layers.

Third Embodiment

A third embodiment uses a group III-V epitaxial technique to manufacture a high-electron-mobility transistor (HEMT) **3**.

Referring to FIG. **20**, a p-type silicon substrate **302** with a p-type Si_xGe_{1-x} (x=0~1) layer **304** formed thereon is prepared. Hereinafter, the p-type silicon substrate **302** together with the p-type Si_xGe_{1-x} layer **304** are referred to as an Si_xG_{1-x}, substrate **300**. After cleaning, a first silicon dioxide layer **306** is deposited on the Si_xGe_{1-x} substrate **300**.

Referring to FIG. **21**, a dummy gate **306***a* and a residual first silicon dioxide layer **306***b* are defined by using photolithography. The Si_xGe_i, substrate **300** is doped with P dopant by self-aligned ion implantation using the dummy gate **306***a* and the residual first silicon dioxide layer **306***b* as a mask, so as to form n^+ source-drain **308**. Referring to FIG. **22**, a second silicon dioxide layer **310** is deposited to cover the entire surface. Then, the n^+ source-drain **308** are activated at high temperature.

Referring to FIG. **23**, the dummy gate **306***a* and the second silicon dioxide layer **310** above are removed by etching.

Referring to FIG. **24**, a resist PR is formed on the residual second silicon dioxide layer **310** as an etching mask, and the Si_xGe_i, substrate **300** is etched to a depth required for a subsequent stacked element, so as to form a recess **330**.

Referring to FIG. **25**, the resist PR is removed. A group III-V undoped moderate-energy-gap confinement layer **312**, a group III-V undoped small-energy-gap channel layer **314**, a group III-V undoped large-energy-gap spacer layer **316**, and a group III-V n^+-doped large-energy-gap confinement layer **318** are sequentially formed in the recess **330** as a stacked element having a group III-V two-dimension electron gas structure **320** by epitaxy.

Referring to FIG. **26**, contact holes **322** are defined in the residual second silicon dioxide layer **310** above the source-drain **308**.

Referring to FIG. **27**, source-drain plug contacts **324** are formed in the contact holes **322** by metallization process. A metal gate **326** is formed on the stacked element having a group III-V two-dimension electron gas structure **320**. Finally, a backside contact **328** made of Al is formed on the side of the silicon substrate **302** opposite to the above-grown layers.

Fourth Embodiment

A fourth embodiment uses a group III-V epitaxial technique to manufacture an MOS high-electron-mobility transistor (MOS-HEMT) **4**.

Referring to FIG. **28**, a silicon substrate **402** with an Si_xGe_{1-x} (x=0~1) layer **404** formed thereon is prepared. Hereinafter, the silicon substrate **402** together with the Si_xGe_{1-x} layer **404** are referred to as an Si_xGe_{1-x} substrate **400**. After cleaning, a first silicon dioxide layer **406** is deposited on the Si_xGe_{1-x} substrate **400**.

Referring to FIG. **29**, a dummy gate **406***a* and a residual first silicon dioxide layer **406***b* are defined by using photolithography. The Si_xGe_{1-x} substrate **400** is doped with P dopant by self-aligned ion implantation using the dummy gate **406***a* and the residual first silicon dioxide layer **406***b* as a mask, so as to form n^+ source-drain **408**. Referring to FIG. **30**, a second

silicon dioxide layer **410** is deposited to cover the entire surface. Then, the source-drain **408** are activated at high temperature.

Referring to FIG. **31**, the dummy gate **406***a* and the second silicon dioxide layer **410** above are removed by etching.

Referring to FIG. **32**, a resist PR is formed on the residual second silicon dioxide layer **410** as an etching mask, and the Si_xGe_{1-x} substrate **400** is etched to a depth required for a subsequent stacked element, so as to form a recess **432**.

Referring to FIG. **33**, the resist PR is removed. A group III-V undoped moderate-energy-gap confinement layer **412**, a group III-V undoped small-energy-gap channel layer **414**, a group III-V undoped large-energy-gap spacer layer **416**, and a group III-V n^+-doped large-energy-gap confinement layer **418** are sequentially formed in the recess **432** as a stacked element having a group III-V two-dimension electron gas structure **420** by epitaxy. A high-dielectric-constant gate dielectric layer **422** is formed on the stacked element having a group III-V two-dimension electron gas structure **420**.

Referring to FIG. **34**, contact holes **424** are defined in the second silicon dioxide layer **410** and high-dielectric-constant gate dielectric layer **422** above the n^+ source-drain **408**.

Referring to FIG. **35**, source-drain plug contacts **426** are formed in the contact holes **424** by metallization process. A metal gate **428** is formed on the group III-V two-dimension electron gas structure **420**. Finally, a backside contact **430** made of Al is formed on the side of the silicon substrate **402** opposite to the above-grown layers.

Fifth Embodiment

A fifth embodiment uses a group IV epitaxial technique to manufacture a quantum well field effect transistor **5**.

A group III-V substrate **502**, such as GaAs, is prepared. Referring to FIG. **36**, the group III-V substrate **502** is etched to a depth required for a subsequent stacked element, so as to form a recess **524**.

Referring to FIG. **37**, a group III-V first large-energy-gap confinement layer **504**, a group III-V small-energy-gap channel layer **506**, and a group III-V second large-energy-gap confinement layer **508** are sequentially formed in the recess **524** as a stacked element having a group III-V quantum well structure **510** by epitaxy.

Referring to FIG. **38**, a silicon oxide layer **512** is deposited to cover the entire surface. Referring to FIG. **39**, a dummy gate **512***a* and a residual silicon dioxide layer **512***b* are defined by using photolithography. Referring to FIG. **40**, a resist PR is formed on the dummy gate **512***a* and the residual silicon dioxide layer **512***b* as an etching mask, and the exposed part of the group III-V substrate **502** is etched to form a source-drain recess **514**.

Referring to FIGS. **41~42**, the resist is removed. The source-drain recess **514** is filled with a group IV SiGe material **516** by selective heteroepitaxy. The group IV SiGe material **516** is N-type doped by self-aligned ion implantation using the dummy gate **512***a* and the residual silicon dioxide layer **512***b* as a mask, so as to form source-drain **518**. Then, the source-drain **518** is activated at high temperature.

Referring to FIG. **43**, the dummy gate **512***a* is removed. Referring to FIG. **44**, a metal gate **520** is formed on the group III-V quantum well structure **510**. Source-drain contacts **522** are formed on the source-drain **518**.

Simulation Results of Electrical Properties

Hereinafter, the electrical properties of a field effect transistor having a group III-V channel and group IV source-drain is simulated by using ISE-TCAD simulation software, so as to evaluate the effect of the prevent invention. Here, the field effect transistor according to the present invention, to be evaluated, has a GaAs channel in cooperation with a Ge source-drain structure, as shown in an appendix, and is used to compare with GaAs n-MOSFET and prior Si n-MOSFET. The main difference among the three FETs is the doping concentration of source-drain. The constituent and doping conditions are listed in Table 1.

TABLE 1

Device Structure	GaAs MOSFET with Germanium Source-drain	GaAs MOSFET	Si MOSFET	Note
Substrate (GaAs, Si)		p-type, 5×10^{17} cm^{-3}		Thickness = 1 µm
Gate Dielectric		HfO_2, 5 nm (EOT = 1 nm)		
Gate Material		Al Metal (work function = 4.1 eV)		
Spacer		SiO_2, length = 50 nm		
Source-drain Material	Ge (6×10^{19} cm^{-3})	GaAs (1×10^{19} cm^{-3})	Si (1×10^{20} cm^{-3})	Gaussian dopant profile
Source-drain Junction Extension		Depth = 40 nm		
Source-drain Junction		Depth = 80 nm		
Halo Implantation		p-type, 2×10^{18} cm^{-3}		Gaussian dopant profile

FIGS. **45~47** are graphs showing the electrical properties I_D-V_G, G_M-V_G, and I_D-V_D of three kinds of MOSFETs listed in Table 1, respectively. Here, the simulated channel size is 100 nm. As can be seen from FIGS. **45** and **46**, the MOSFET with a high-carrier-mobility group III-V channel can be used to efficiently enhance the characteristics of driving current and conductance, and the GaAs n-MOSFET with Ge source-drain can further improve the whole device characteristics. For convenient comparison, the electrical properties of three kinds of MOSFETs listed in Table 1, shown in FIGS. **45-47**, are summarized in Table 2.

TABLE 2

	I_D(µA/µm) @	I_D(µA/µm) @

	G_M(μS/μm) @ V_d = 0.1 V	Enhancement (%)	$V_g - V_{th}$ = 0.5 V, V_d = 0.1 V	Enhancement (%)	$V_g - V_{th}$ = 0.5 V, V_d = 1 V	Enhancement (%)
Si MOSFET	436	—	173	—	362	—
GaAs MOSFET	895	105	334	93	459	27
GaAs MOSFET with Ge source-drain	1004	130	409	136	544	50

It can be seen from Table 2 that, for the conductance G_M characteristic, as compared with the Si MOSFET, the enhancement of the GaAs MOSFET with Ge source-drain according to the present invention reaches 130%, and as compared with the GaAs MOSFET, 12% enhanced. For the driving current I_D characteristic, as compared with the GaAs MOSFET, the enhancement of the GaAs MOSFET with Ge source-drain according to the present invention in linear zone and saturation zone reach 22% and 18%, respectively.

According to the simulation results of the above field effect transistors, the hetero field-effect element with group III-V channel and group IV source-drain according to the present invention significantly improves the electrical properties. In addition, the epitaxy technique proposed by the present invention can be applied to other types of field effect elements, such as high-electron-mobility transistors.

INDUSTRIAL UTILITY

The semiconductor device manufactured according to the present invention can be applied to logic element products, for example, metal-oxide semiconductor transistors, high-electron-mobility transistors (HEMT), or quantum well transistors formed on a Si_xGe_{1-x} (x=0~1) top layer or Si(Ge) substrate.

Although the invention has been described with reference to the preferred embodiments, various modification and substitutions can be easily made without departure from the spirit and scope of the present invention which is defined by claims below.

A LIST OF REFERENCE NUMERALS

1 metal-oxide semiconductor field effect transistor
2 quantum well field effect transistor
3 high-electron-mobility transistor
4 metal-oxide semiconductor high-electron-mobility transistor
5 quantum well field effect transistor
10 silicon substrate
12 deep source-drain region
14 shallow source-drain region
16 sidewall spacer
17 sidewall spacer
20 dielectric layer
24 sidewall spacer
26 trench
28 epitaxial material
30 N-type metal layer
32 dielectric layer
100 Si_xGe_{1-x} substrate
102 P-type silicon substrate
104 P-type Si_xGe_{1-x} layer
106 first silicon dioxide layer
106*a* dummy gate
106*b* residual first silicon dioxide layer
108 n^+ source-drain
110 second silicon dioxide layer
112 high-electron-mobility group III-V channel layer
114 high-dielectric-constant gate dielectric layer
116 contact holes
118 source-drain plug contacts
120 metal gate
122 backside contact
124 recess
200 Si_xGe_{1-x} substrate
202 P-type silicon substrate
204 P-type Si_xGe_{1-x} layer
206 first silicon dioxide layer
206*a* dummy gate
206*b* residual first silicon dioxide layer
208 n^+ source-drain
210 second silicon dioxide layer
212 group III-V first large-energy-gap confinement layer
214 group III-V small-energy-gap channel layer
216 group III-V second large-energy-gap confinement layer
218 stacked element having a group III-V quantum well structure
220 contact hole
222 source-drain plug contact
224 metal gate
226 backside contact
228 recess
300 Si_xGe_{1-x} substrate
302 P-type silicon substrate
304 P-type Si_xGe_{1-x} layer
306 first silicon dioxide layer
306*a* dummy gate
306*b* residual first silicon dioxide layer
308 n^+ source-drain
310 second silicon dioxide layer
312 group III-V undoped moderate-energy-gap confinement layer
314 group III-V undoped small-energy-gap channel layer
316 group III-V undoped large-energy-gap spacer layer
318 group III-V n^+-doped large-energy-gap confinement layer
320 stacked element having a group III-V two-dimension electron gas structure
322 contact hole
324 source-drain plug contact
326 metal gate
328 backside contact
330 recess
400 Si_xGe_{1-x} substrate
402 P-type silicon substrate
404 P-type Si_xGe_{1-x} layer
406 first silicon dioxide layer
406*a* dummy gate
406*b* residual first silicon dioxide layer
408 n^+ source-drain
410 second silicon dioxide layer
412 group III-V undoped moderate-energy-gap confinement layer
414 group III-V undoped small-energy-gap channel layer
416 group III-V undoped large-energy-gap spacer layer

418 group III-V n^+-doped large-energy-gap confinement layer
420 stacked element having a group III-V two-dimension electron gas structure
422 high-dielectric-constant gate dielectric layer
424 contact hole
426 source-drain plug contact
428 metal gate
430 backside contact
432 recess
502 group III-V substrate
504 group III-V first large-energy-gap confinement layer
506 group III-V small-energy-gap channel layer
508 group III-V second large-energy-gap confinement layer
510 stacked element having a group III-V quantum well structure
512 silicon dioxide layer
512*a* dummy gate
512*b* residual silicon dioxide layer
514 source-drain recess
516 group IV SiGe material
518 source-drain
520 metal gate
522 source-drain contact
524 recess
PR resist

What is claimed is:

1. A method for manufacturing a semiconductor device with group III-V channel and group IV source-drain, comprising:

preparing a substrate, the substrate being a group III-V substrate or a Si substrate with GaN grown thereon;

forming a recess in the substrate by etching, the recess having a depth required for forming a channel-containing stacked element by subsequent epitaxy;

forming the channel-containing stacked element in the recess by epitaxy;

depositing a dummy gate material layer on the substrate and defining a dummy gate from the dummy gate material layer by photolithography;

forming a source-drain recess on the substrate by using the dummy gate as a mask;

filling the source-drain recess with a group IV material by selective heteroepitaxy using the dummy gate as a mask;

doping the group IV material by self-aligned ion implantation and activating the group IV material at high temperature, so as to form source-drain;

removing the dummy gate; and

forming a gate on the channel-containing stacked element.

2. A method of claim **1**, wherein the crystal plane of the substrate is (100), (110), or (111), and its off-cut angle is 2, 4, or 6 degrees.

3. A method of claim **1**, wherein the dummy gate material layer is a single layer made of insulating material or a stacked layer made of a plurality of insulating materials.

4. A method of claim **3**, wherein the material of the dummy gate material layer is silicon oxide, silicon oxynitride, aluminum oxynitride, or hafnium oxynitride.

5. A method of claim **1**, wherein the source-drain are made of doped Si_xGe_{1-x} (x=0~1) or silicon germanium carbide.

6. A method of claim **1**, wherein the channel-containing stacked element has a metal-oxide semiconductor structure, a quantum well structure, or a two-dimension electron gas structure, wherein the metal-oxide semiconductor structure consists of a metal layer, a high-dielectric-constant dielectric layer, and a group III-V channel layer; the quantum well structure consists of a large-energy-gap material layer, a small-energy-gap material layer functioning as a channel, and a large-energy-gap material layer; the two-dimension electron gas structure consists of a large-energy-gap heavily doped material layer, a large-energy-gap undoped material layer, a small-energy-gap undoped material layer functioning as a channel, and a moderate-energy-gap undoped material layer.

7. A method of claim **6**, wherein the metal-oxide semiconductor structure consists of a TaN layer, an HfO_2 layer, and an InGaAs layer.

8. A method of claim **6**, wherein the metal-oxide semiconductor structure consists of a TiN layer, an Al_2O_3 layer, and an InSb layer.

9. A method of claim **6**, wherein the quantum well structure consists of a GaAs layer, a Ge layer, and a GaAs layer.

10. A method of claim **6**, wherein the quantum well structure consists of a GaAs layer, an InGaAs layer, and a GaAs layer.

11. A method of claim **6**, wherein the two-dimension electron gas structure consists of an N type AlGaAs layer, an AlGaAs layer, an InGaAs layer, and a GaAs layer.

12. A method of claim **6**, wherein the two-dimension electron gas structure consists of an N type AlInAs layer, an AlInAs layer, an InGaAs layer, and an AlInAs layer.

13. A method of claim **1**, wherein the material of the channel is InN, GaN, AlN, InP, InAs, InSb, GaAs, GaSb, or a compound consisting of them with different proportions.

14. A method of claim **1**, wherein the epitaxy is performed by using a film formation system selected from the group consisting of a metal organic chemical vapor deposition (MOCVD) system, a molecular beam epitaxy (MBE) system, an ultra-high vacuum chemical vapor deposition (UHVCVD) system and an atomic layer deposition (ALD) system.

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